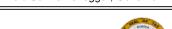
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-019647 Address: 333 Burma Road **Date Inspected:** 29-Dec-2010

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

Mr. Liu Fa Wen **CWI Name: CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** OBG

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #8

This QA Inspector observed the following work in progress

Orthotropic Box Girder (OBG)

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint # 044 as per WRR no. B-WR 19566, located on Bike path, OBG Component BK 004A1 -060. Welder is identified as 037840. ZPMC Quality Control (QC) Inspector is identified as Liu Fa Wen. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -1G (1F) -Repair.

Repair welding of Weld joint # 006 as per WRR no. B-WR 19563, located on Bike path, OBG Component BK 004ASD1 -060. Welder is identified as 069894. ZPMC Quality Control (QC) Inspector is identified as Liu Fa Wen. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) -Repair.

Repair welding of Weld joint # 018 located on Bike path, OBG Component BK 004A2 -064. Welder is identified

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

as 058009. ZPMC Quality Control (QC) Inspector is identified as Liu Fa Wen. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -1G (1F) -Repair.

Weld joint # 104, located on Bike path, OBG Component BK 004A4 -057. Welder is identified as 037840. ZPMC Quality Control (QC) Inspector is identified as Liu Fa Wen. The welding variables recorded by QC appeared to comply with the WPS – B –P -2114.

Flux cored Arc welding (FCAW)

Weld joint # 068, located on OBG Component, Bike path BK 004A3 -057. Welder is identified as 054459. ZPMC Quality Control (QC) Inspector is identified as Zhang Ya Xu. The welding variables recorded by QC appeared to comply with the WPS – B-T-2132-Esab.

Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 07970

This QA inspector performed (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an TL 6028 MT report for this date. The member is identified as OBG Bike path components. The weld designations reviewed are as follows:

BK004ASD1 -063 -Jt. nos- 005,006,018,021 BK004A1 -063 -Jt. nos.-043, 044

Ultrasonic Testing (UT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 07975

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report (TL 6027) for this date. The member is identified as OBG Bike path components. The weld designation reviewed as follows:

BK004A5 -064 – Jt. nos. -112, 122 BK004A5 -064 -Jt. no. 008 BK004A3 -064 -Jt. no. 002

Visual Inspection Testing (VT):

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 07979

This QA inspector performed Visual Inspection (VT) of 100% of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as Bike path closure plates at both ends. The weld designations reviewed are as follows:

BK004A -057

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.





Summary of Conversations:

No relevent Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan Quality Assurance Inspector

WELDING INSPECTION REPORT (Continued Page 4 of 4)

Reviewed By: Clifford,William QA Reviewer